



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5371-1
Job Sheet 180158



Part No: D5371-1

Job Qty: 6 ea

Part Name: Hook



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/29/18

Job Tracking No:

Due Date: 7/27/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV.A NEW ISSUE JFS 15/12/14 VERIFIED BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	7/27/18	7/27/18	0.00	0.00	Start Up Machining-4		
100	Bandsaw	6 pcs	7/27/18	7/27/18	0.00	0.00	Bandsaw1		
110	CNC Vertical Machining	6 pcs	7/27/18	7/27/18	0.00	5.87	HAAS 5 Axis		
120	QC	6 pcs	7/27/18	7/27/18	0.00	0.00	QC2 Machining-4		
130	QC	6 pcs	7/27/18	7/27/18	0.00	0.00	QC8 Machining-4		
140	HandFinish	6 pcs	7/27/18	7/27/18	0.00	0.27	HandFinish1		
150	Powdercoat	6 pcs	7/27/18	7/27/18	0.00	0.21	Powdercoat11		
155	QC	6 pcs	7/27/18	7/27/18	0.00	0.00	QC3		
180	Packaging	6 pcs	7/27/18	7/27/18	0.00	0.00	Packaging3-2		
190	QC21-SA	6 Ea	7/27/18	7/27/18	0.00	0.00	QC21		

Part Op 120 - QC2- Inspect parts off machine FAI/FAIB
Descriptions: 130 - QC8- Inspect parts - second check
140 - Chemical Conversion Coat per QSI005 4.1
150 - Gloss Black (Alum) (Ref:QSI005 4.3.5.13)
155 - QC3- Inspect Part Finish
180 - Identify as per dwg & Stock Location: _____
190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X06.000	6061T6 Bar 1.00 X 6.00	1.6260 ft (.271 ea)	90-Start up Operation	5097187

Job Allocations

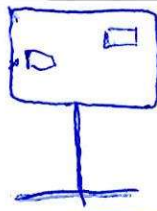
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X06.000	2	26	0

Part Specifications

Specifications could not be found.

Plex 6/29/18 9:49 AM Dart.lajeunesse.marie

DAS
9
9-89



DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only



Work Order: _____		DISPOSITION				AGAINST DEPARTMENT/PROCESS				MRB (QSI042) Approval																			
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐				Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐				Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐				Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐				Engineering Quality Other ☐											
NCR No. _____		Suspected Unapproved ☐																											
Date: _____		Description WOI																											
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com DART AEROSPACE Container No: S097189 Part: D5371-1 Job No: 180158 Serial No/Batch: S097189 Revision: Inspector: Exp Date: Instructions: Various STC's Date: 07/26/18																													
Root Cause																													
Environment										No Re-verification																			
Design										Operator																			
Doc/Data										Offset/Setup																			
Equip/Tooling										Supplier																			
Handling/Pre										Training																			
Material										Use for Testing																			
Internal Transport										Poor Information																			
Tribal Knowledge										Rushing																			
LOA										Product Improvement																			
Substation										Process Improvement																			
Past Expiry Date										Manufacturing Process																			
Misidentified										Past Due																			
OTHER :																													
Crimp/Kink/Ripple/Wave										Inspection Incomplete/Unqualified										Wrong Stock Pulled									
Cuffs										Contamination										Out of Sequence									
Crushing										Countersink										Off-set									
Heat Treat										Cut Too Short										Misabeled									
Wave/Twist in Tube										Instructions Incomplete/Unclear										Fit/Function									
Marks/Chatter										Drill Holes										Misaligned/off center									
Positioned Wrong										Outside Dimensions										Over/Under tolerance									
Part Incorrect										Part Lost/Missing										Part Moved									
Drawing										Finish										Misread									
Turning Sequence																													
QC / QA Coordinator Approval										Lead hand / Supervisor Approval Verification										Completed By									

DART AEROSPACE LTD		Work Order: 180158
Description: Hook		Part Number: D5371-1
Inspection Dwg: D5371	Rev: A	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.45	+/-0.030	5.451	✓		SLID	Vein
R0.25	+/-0.030	.250	✓		Rad gauge	
R0.28	+/-0.030	.280	✓		"	
30°	+/-0.5°	30°	✓		Protractor	
R0.39	+/-0.030	.390	✓		Rad gauge	
10°	+/-0.5°	10°	✓		Protractor	
R0.28	+/-0.030	.280	✓		Rad gauge	
34°	+/-0.5°	34°	✓		Protractor	
R0.39	+/-0.030	.390	✓		Rad gauge	
0.86	+/-0.030	.864	✓		SLID	Vein
0.200	+/-0.010	.198	✓		↓	
2.29-2.28	+/-0.030	2.290	✓		↓	
R0.16	+/-0.030	.160	✓		Rad gauge	
70°	+/-0.5°	70°	✓		Protractor	
0.40	+/-0.030	.402	✓		SLID	Vein
2.61	+/-0.030	2.610	✓		↓	
0.174 x 45°60°	+/-0.010 x +/-0.5°	.170	✓		↓	
Ø0.204	+0.005/-0.001	.204	✓		↓	
0.374	+/-0.010	.374	✓		↓	
0.748	+/-0.010	.753	✓		↓	
0.35	+/-0.030	.349	✓		↓	
0.750	+/-0.005	.750	✓		↓	
3.250	+/-0.005	3.250	✓		↓	
0.550	+/-0.010	.551	✓		↓	
R0.13	+/-0.030	.130	✓		Rad gauge	
R0.02	+/-0.030	.015	✓		"	
1.97	+/-0.030	1.968	✓		SLID	Vein
2.43	+/-0.030	2.426	✓		↓	
1.87	+/-0.030	1.864	✓		↓	
0.050	+0.005/-0.000	.053	✓		↓	
	+0.010/-0.000					

Measured by: DAS 20	Checked by: KJ 1	QC Inspector:
Date: 18-07-28	Date: 18-07-20	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	16.03.30	New Issue	KJ	